

Abstract

The invention provides a build-up mold for continuous casting that can be produced at low costs by simplifying cumbersome positioning operations when milling or cutting slit grooves in a copper plate that becomes a cooling plate, is able of making uniform the cooling efficiency over the entirety of the cooling plate by adjusting pressure loss and flow amount of cooling water flowing into the respective slit grooves, and is able to prevent break-out and defects of molded pieces in continuous casting of molten metal without generating strains in the cooling plate, wherein the yield of molded pieces can be improved. The build-up mold for continuous casting 10, in which a cooling plate supporting panel 17 is attached, via tightening members 13 through 15, to the opening side of slit grooves of the cooling plate 11 in which a number of slit grooves 20 through 29 becoming flow passes of cooling water are formed, is characterized in that the widths of the slit grooves 20, 29 disposed so as to bypass the tightening members 13 through 15 in the vicinity thereof are formed to be wider than the widths of the slit grooves which are disposed in a range having a high cooling efficiency between the tightening members, and the depths of the slit grooves are formed to be roughly equal to each other.